

Work Order ID 73077

Thursday, August 25, 2011 11:43:16 AM



Aug 31st

Page 1

Item ID: D205-778-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Comfort Seat, LH/RH

Start Date: 8/25/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: ME

Date: 11-08-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3800	B
DSI 9508	A
IIN D205-778	Rev B

100



DC

Document Control

DOCUMENT CONTROL

X

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP D205-778-011 CHG 003

S. W. 10/10/06

CL 11-8-29

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/8/29

308

Work Order ID 73077

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Page 2

Item ID: D205-778-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Comfort Seat, LH/RH

Start Date: 8/25/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		Subalob		(f3)			
130 Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D205-778-101 Location: _____ PPP Rev: _____	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/9/69
mf
11-09-06

Picklist Print

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Page 1

Work Order ID: 73077

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 8/25/2011

Required Date: 8/25/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6L Washer		Purchased	No			110	Each	896.0000	16	48			
<div>Location</div> <div>ST347</div> <div>5519</div> <div>Loc Qty</div> <div>896</div> <div>896</div> <div>Loc Code</div>													
BSP-42 Rivet		Purchased	No			110	Each	120.0000	8	24			
<div>Location</div> <div>ST284</div> <div>114598</div> <div>Loc Qty</div> <div>120</div> <div>120</div> <div>Loc Code</div>													
D3752-1 Seat Frame		Manufactured	No			110	Each	1.0000	1				
<div>Location</div> <div>ST252A</div> <div>67226</div> <div>Loc Qty</div> <div>1</div> <div>1</div> <div>Loc Code</div>													
D3755-041 Seat Cushion		Manufactured	No			110	Each	6.0000	1	3			
<div>Location</div> <div>ST252A</div> <div>68934</div> <div>71183</div> <div>Loc Qty</div> <div>6</div> <div>2</div> <div>4</div> <div>Loc Code</div>													

81 B73076 (24) 11/9/12

11/8/29

28

Picklist Print

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Work Order ID: 73077

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 8/25/2011

Required Date: 8/25/2011

Start Qty: 3.00

Required Qty: 3.00

D3756-041

Manufactured No

110

Each

6.0000

1



Cushion

Location

Loc Qty

Loc Code

ST252A

6

68935

2

71184

4

D3758-041

Manufactured No

110

Each

9.0000

2



Clamp

Location

Loc Qty

Loc Code

ST081

9

58262

9

D3777-041

Manufactured No

110

Each

6.0000

2



Clamp

Location

Loc Qty

Loc Code

ST081

6

46659

6

D3800-3-200

Manufactured No

110

f

128.9000

2



Hook and Loop Strip (2" Hard)

Location

Loc Qty

Loc Code

ST083

128.9

56393

68.9

60044

60

1- Cut to length as per dwg (4x 6.00")

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Shop Packet Print

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Page 3

Work Order ID: 73077

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 8/25/2011

Required Date: 8/25/2011

Start Qty: 3.00

Required Qty: 3.00

AN525-10R8

Purchased

No

110

Each

69.0000

8

24



Screw

Location

Loc Qty

Loc Code

ST325

69

114494

69

AN970-3

Purchased

No

110

Each

78.0000

8

24



Washers

Location

Loc Qty

Loc Code

ST349

78

115158

2

117395

76

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

24



Washer

MS21042L3

Purchased

No

100

Each

1,789.000

8

24



Nut

Location

Loc Qty

Loc Code

ST300

1789

117441

150

117601

400

117885

239

118451

1000

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Shop Packet Print

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REFERENCE**4.0 WEIGHT AND BALANCE**

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 ONLY
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37
REF FAA STC: SR02704NY
REF EASA STC: EASA.IM.R.S.01518

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	12	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED	14	TITLE	SCALE
DE APPR.	14	RIVET KIT	NTS
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